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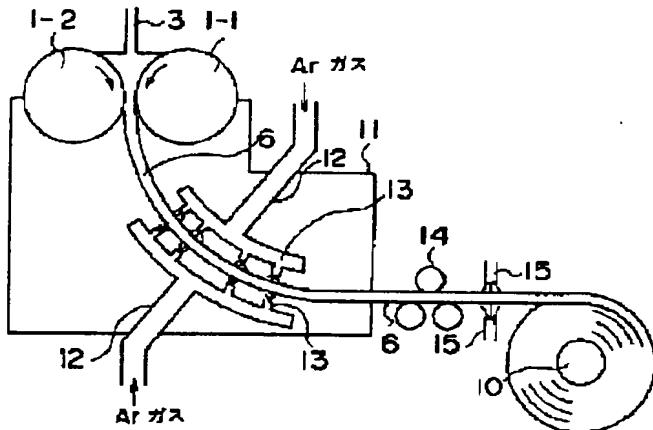
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APPLICANT : NIPPON STEEL CORP;

INVENTOR : NOHARA YOSHIKATSU;

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TITLE : METHOD FOR COILING  
CONTINUOUSLY CAST SLAB BY TWIN  
DRUM TYPE CONTINUOUS CASTING  
MACHINE



ABSTRACT : PURPOSE: To provide a slab free from scattering of scales during a working by descaling a thin slab of carbon steel cooled at a prescribed temperature in an air shut-off chamber consisting of the non-oxidizing atmosphere whose oxygen concentration is below a prescribed value outside the air shut-off chamber, and coiling the thin slab around a coil.

CONSTITUTION: The molten steel 3 cast by drums 1-1, 1-2 becomes a thin slab 6, and when the thin slab is passed through the air shut-off chamber 11 of the non-oxidizing atmosphere whose oxygen concentration is  $\leq 2.0\text{vol.}\%$ , Ar gas is blown from a nozzle 13 against the thin slab. The thin slab 6 is cooled so that the temperature at the outlet of the air shut-off chamber is 400-700°C. A descaler 14 and a water-pouring and rapid cooling device 15 are arranged close to each other, and the thin slab is rapidly cooled after the descaling, and coiled around a coil 10. The adhesivity of the scale generated after the descaling becomes excellent, and no scales are scattered even when the thin slab is formed without any hot rolling or cold rolling to improve the working environment.

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